

(19)



JAPANESE PATENT OFFICE

## PATENT ABSTRACTS OF JAPAN

(11) Publication number: **55112176 A**(43) Date of publication of application: **29.08.80**

(51) Int. Cl.

**B23K 9/12**(21) Application number: **54018592**(22) Date of filing: **19.02.79**(71) Applicant: **OSAKA DENKI KK**(72) Inventor: **KAWAKAMI TAKASHI  
UCHIKOSHI KUNIO****(54) METHOD AND DEVICE FOR CONTROLLING  
WIRE FEEDING**

etc. caused by the slipping and bucking of the wire 2 as in ordinary cases may be eliminated.

**(57) Abstract:**

COPYRIGHT: (C)1980,JPO&amp;Japio

**PURPOSE:** To smoothly feed wire with an extremely simple constitution by changing the position of the flexible free end of the wire guide pipe provided between a push feeder and pull feeder and detecting the deflection of the wire from the change amount thereof.

**CONSTITUTION:** The welding wire 2 coiled on a wire reel 1 is let off by a push feeder 3 and is fed into a pull feeder 5 through a wire guide pipe 4 which is made partly flexible, thence it is further sent to a welding torch 6. Here, the deflection amount of the wire 2 being fed in the pipe 4 is detected from the change amount of the input voltage supplied to the input end of a phase controller 19, so that the rotating speed of the push power device 13 of the feeder 3 is controlled. Hence, even when there are fluctuations in the consumption amount and load of the wire 2, the correct deflection amount of the wire 2 is maintained at all times. As a result of this, the feed speed of the feeder 3 is synchronized to the feed speed of the feeder 5, by which the wire 2 is smoothly fed up to the torch 6. Namely, the welding defects, the damaging of the welding device,

